

Date: Thursday, 10/11/2007 2:51:02 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHUT-OFF VALVE ASSEMBLY
 Job Number : 35110
 Estimate Number : 12186
 P.O. Number : N/A Part Number : D3469041
 This Issue : 10/11/2007 S.O. No. : N/A Drawing Number : D3469 REV A1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : SMALL / MED FAB Drawing Revision : A1
 Previous Run : 34441 Material : N/A Due Date : 10/25/2007 Qty: 2 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev: A New Issue 06-02-03 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D3469043 TUBE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty - Part Number Description
 1 D3469-043 Tube Assembly

Batch

~~B 35111~~ B 35111 x 2mx.

X

mf mf

2.0 D3470041 SHUT-OFF VALVE SHAFT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description
 1 D3470-041 Shut-Off Valve Assembly

Batch

~~B 34426~~ B 35753 x 2mx.
 mf

mf

3.0 D34705 PLATE VALVE



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch
 4 D3470-5 Plate Valve

Batch

~~B 26116~~

B 36125

~~B 26116~~ x 6mx.

B 34411 x 2mx.

mf

4.0 D34707 valve seal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
 2 D3470-7 Valve Seal

Batch

B 34412 x 4mx.

B 34412 x 4mx.

mf

07-12-11

mf 07-10-22



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Job Number: 35110

Part Number: D3469041

Job Number:



Seq. #: Machine Or Operation: Description:

5.0 D34709 BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

BOLT

Batch:

~~B26387~~

B26387

x (2)

mf

mf

6.0 AN3104 NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1

AN310-4

Nut

~~m105280~~

m105280

x (2) mf

mf

7.0 AN9604L washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4

AN960-4L

Washer

~~m101389~~

m101389

x (8) mf

mf

mf

8.0 AN960416 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4

AN960-416

Washer

~~m5519~~

m5519

x (8) mf

mf

mf

9.0 MS24665153 COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

COTTER PIN

Batch:

~~m19096~~

m19096

x (2) mf

mf

mf

10.0 MS35206217 Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4

MS35206-217

Screw

~~m19402~~

m19402

x (8) mf

mf

0710-22

mf 07-12-11

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Drawing Name: SHUT-OFF VALVE ASSEMBLY

Job Number: 35110

Part Number: D3469041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

NAS679A04

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 NAS679-A04 Nut

m102948

m102948 x 8mx

MF 07-12-11

MF

07-10-22

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3469

MF

07-12-11 (2)

MF

07-10-22 (1)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure Unit Opens and Closes Smoothly

5/12/11 (x2)

5/12/11 (x1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: 57154

6/7/12/11 (2)

6/7/10/24

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

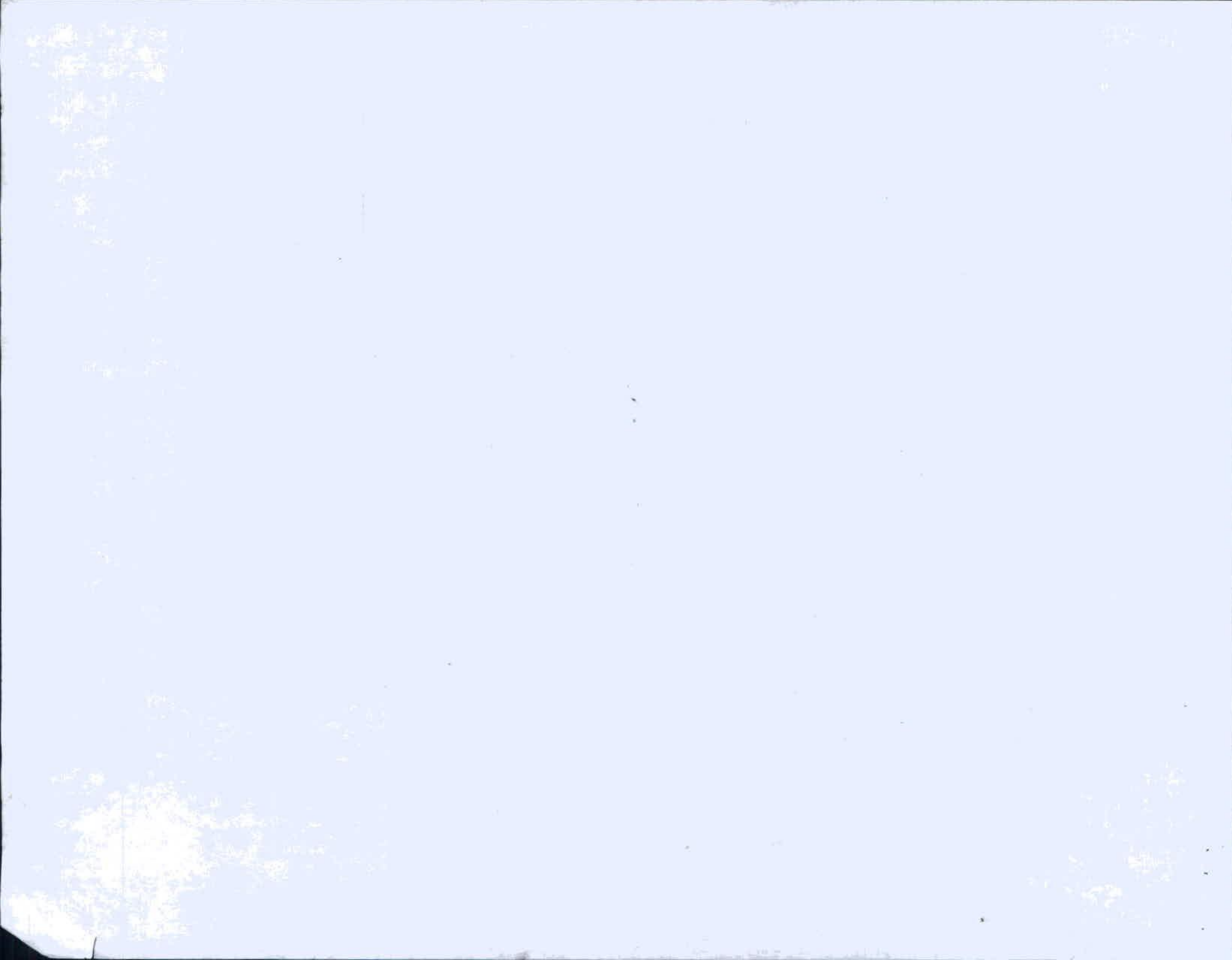
6/7/10/24

Job Completion



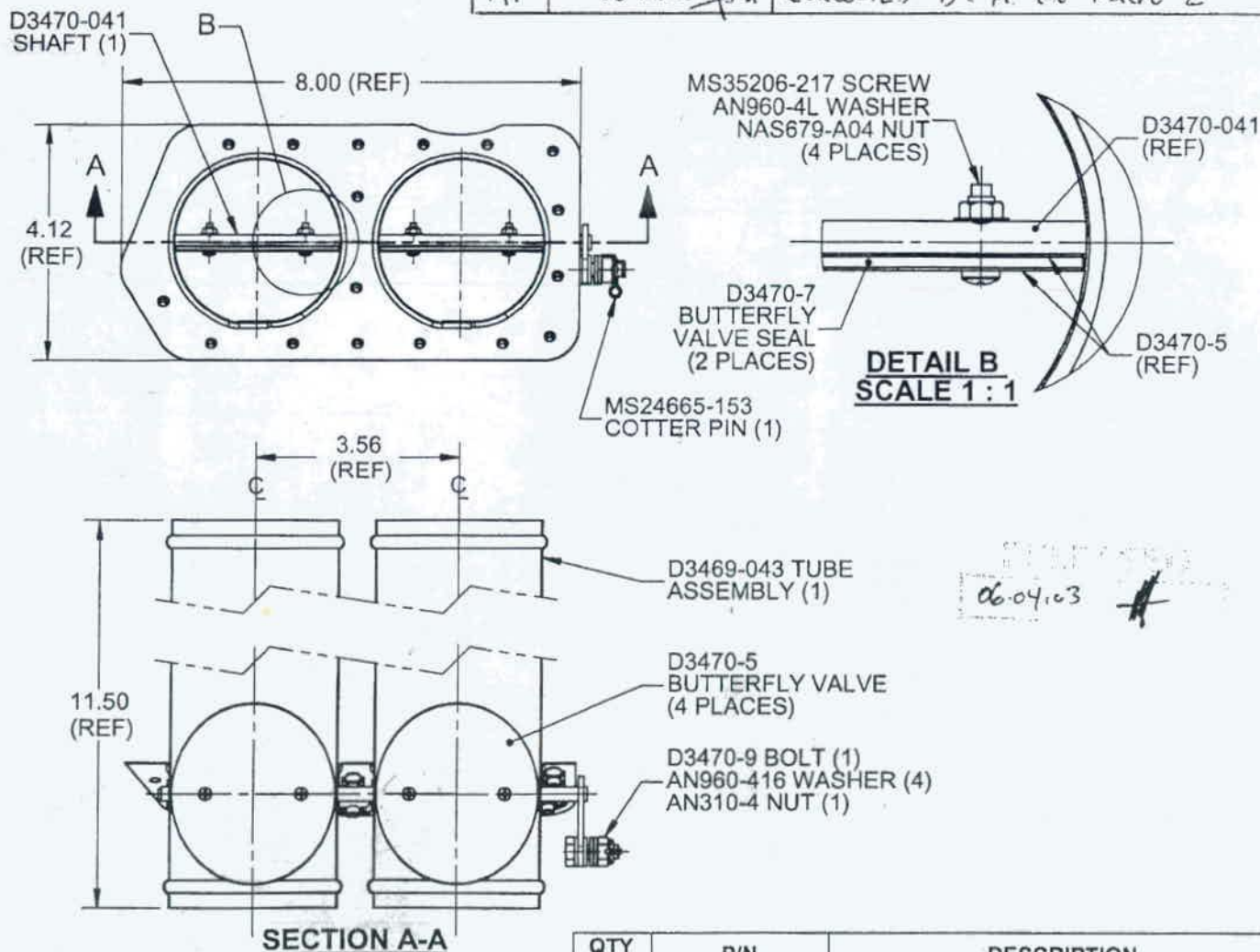
6/7/10/24

6/7/12/12 (2)
6/7/12/12 (2)
6/7/12/12





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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 1 OF 5
DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y		SCALE 1:3
A	05.12.12	NEW ISSUE	
A1	06.04.20	CORRECTED BOM ON PAGE 2	



D3469-041 SHUT-OFF VALVE ASS'Y

NOTES:

- 1) IDENTIFY WITH DART P/N D3469-041 USING FINE POINT PERMANENT INK MARKER
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3469-041	SHUT-OFF VALVE ASSEMBLY
1	D3469-043	TUBE ASSEMBLY
1	D3470-041	SHUT-OFF VALVE SHAFT
4	D3470-5	BUTTERFLY VALVE
2	D3470-7	BUTTERFLY VALVE SEAL
1	D3470-9	BOLT
1	AN310-4	NUT
4	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
4	MS35206-217	SCREW
4	NAS679-A04	NUT

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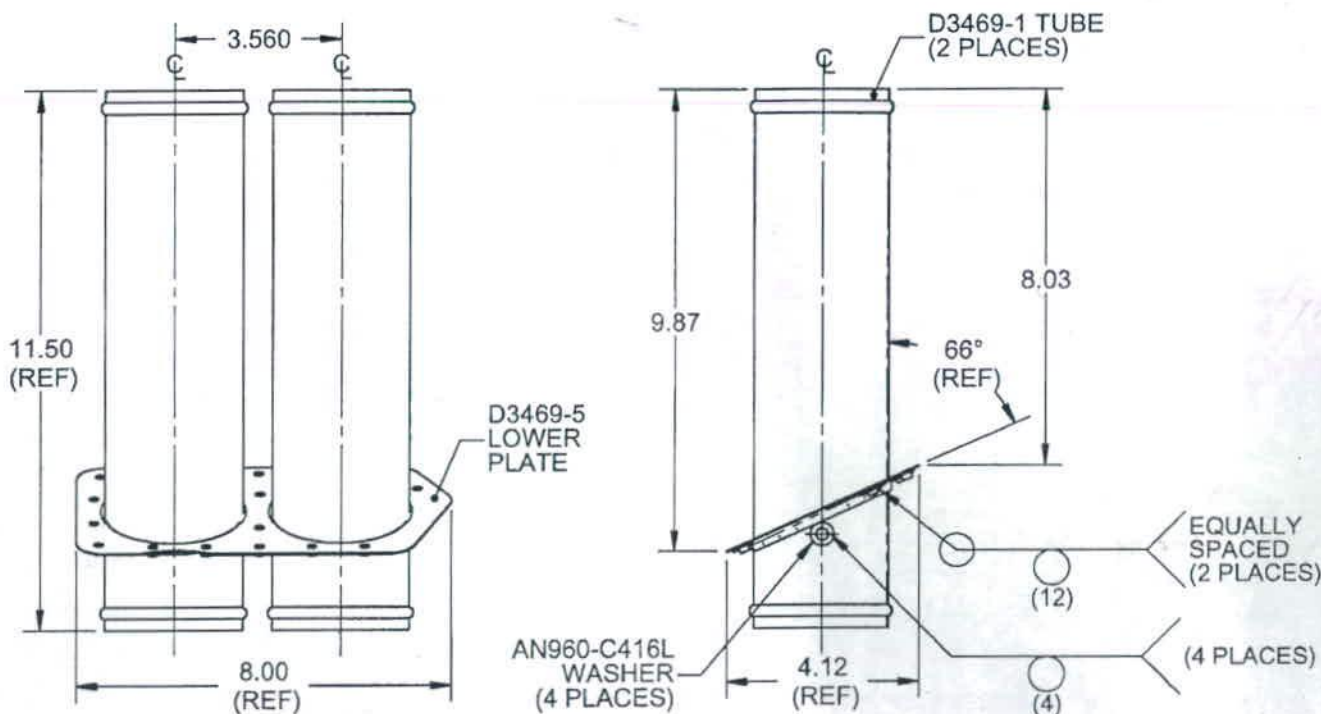
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

06.04.03




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D3469-043 TUBE ASSEMBLY

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	D3470-5	PLATE VALVE 
4	AN960-C416L	WASHER

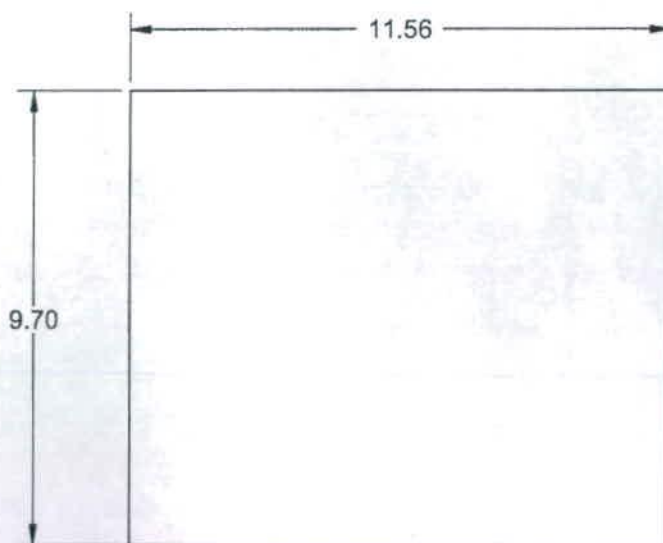
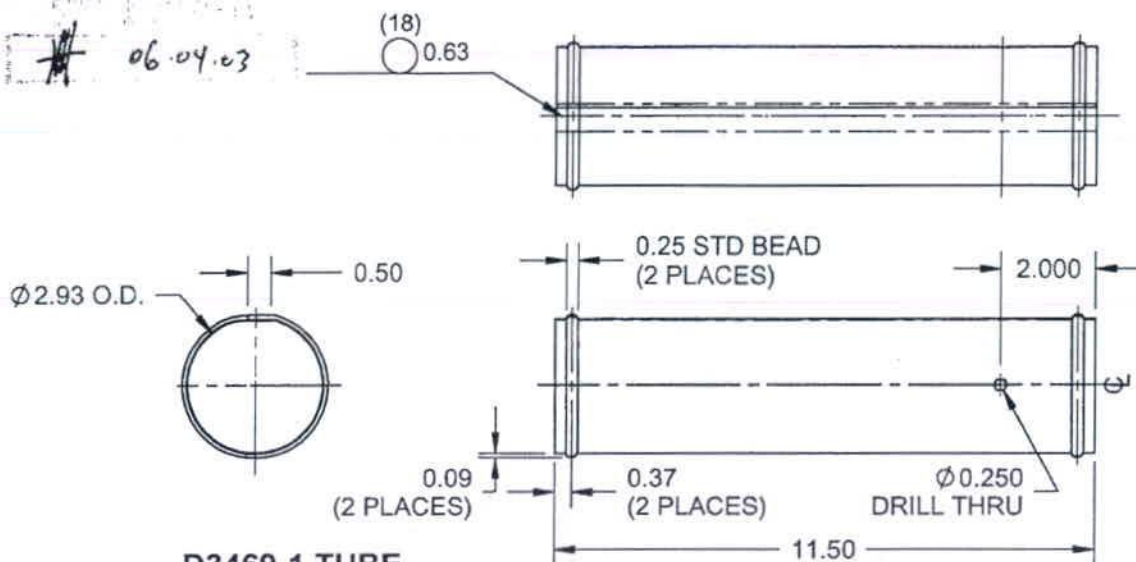
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4



D3469-1F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

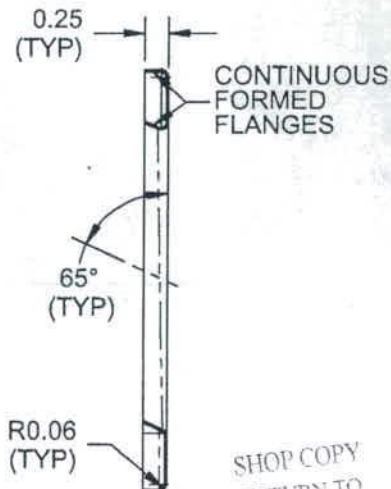
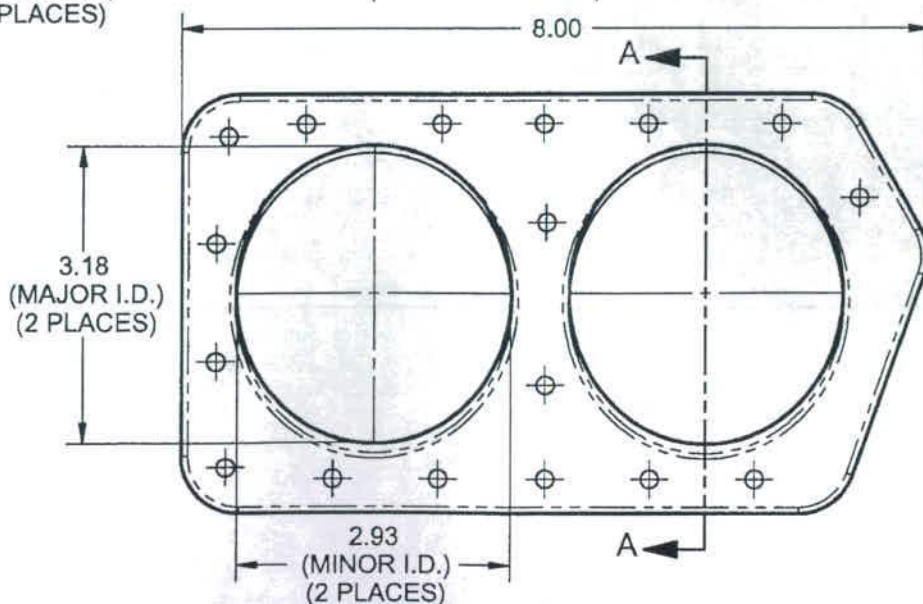
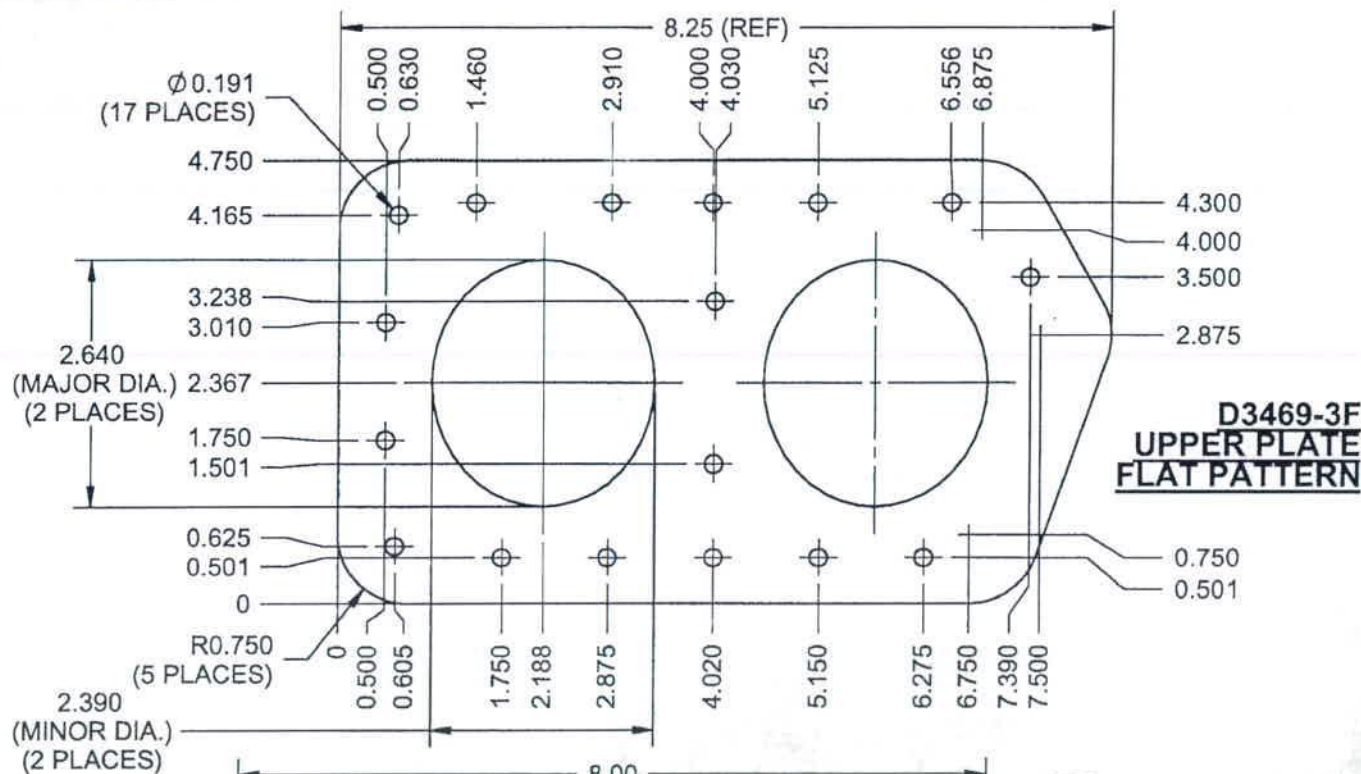
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DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2



NOTES:

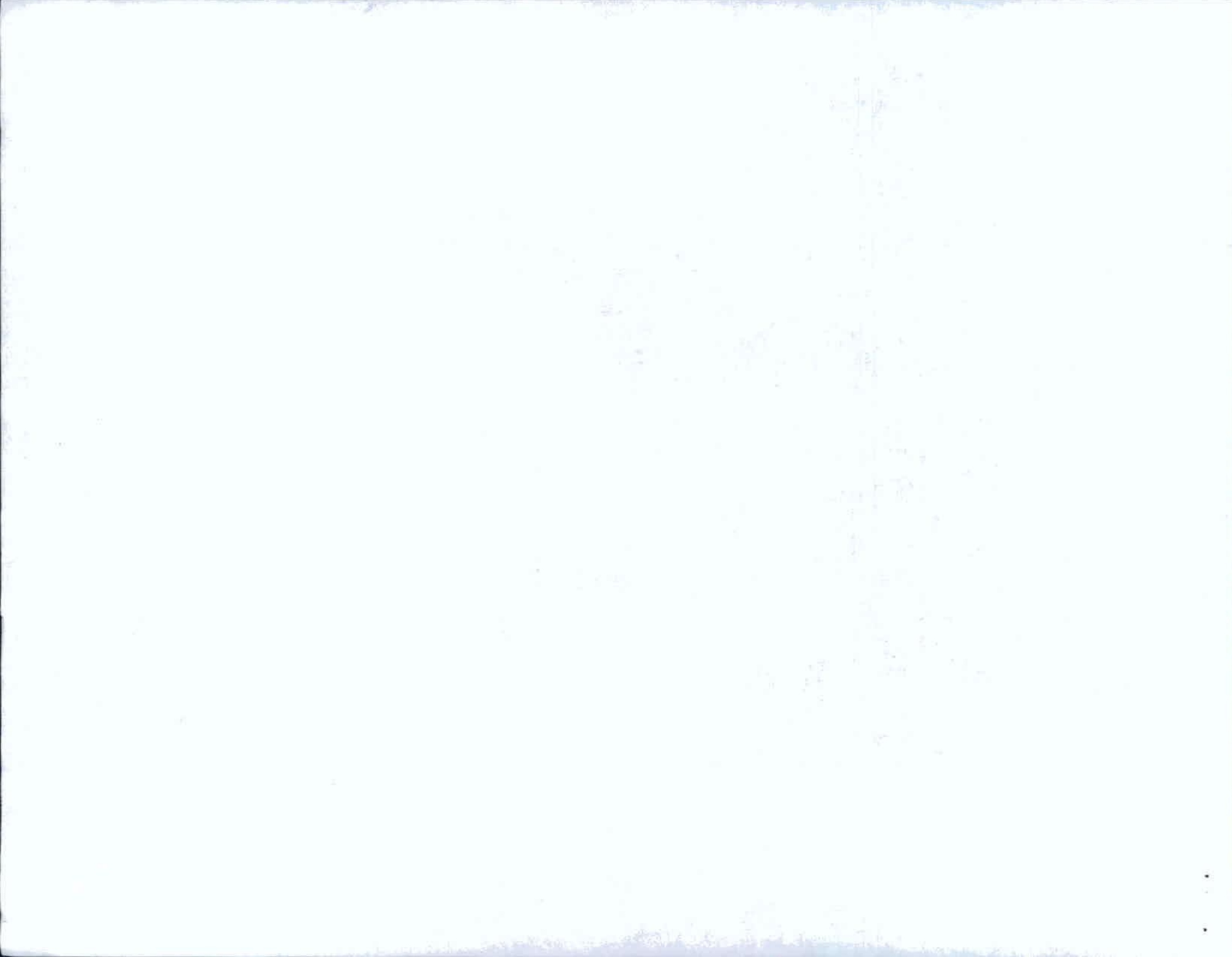
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: NONE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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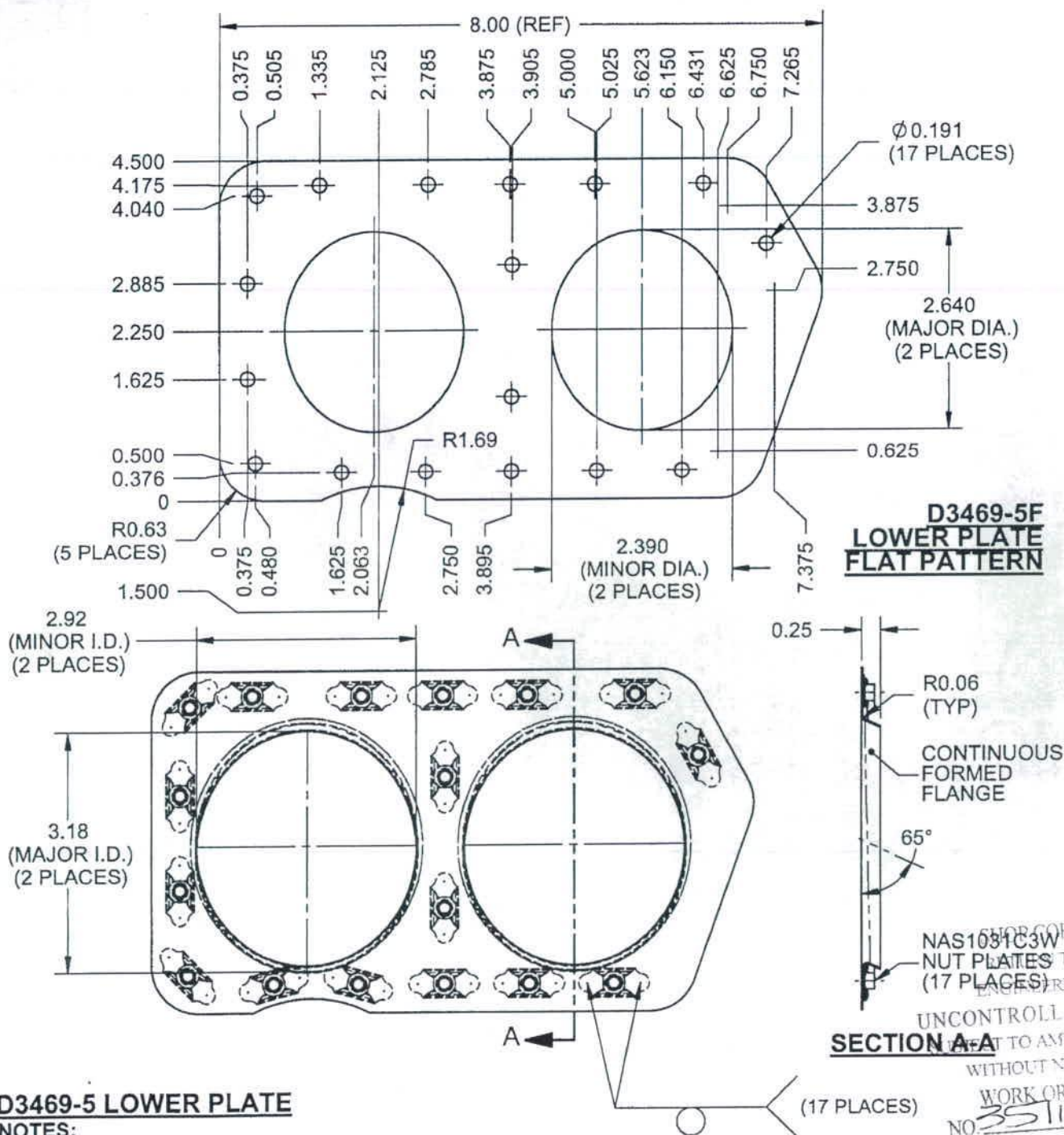
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DATE 05.12.12	TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:2	



D3469-5 LOWER PLATE

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) SPOT WELD NUT PLATES PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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[Signature] 06-04-03

